

Date: Wednesday, 1/24/2007 4:44:08 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|------------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : 212/205 HIGH AFT X-TUBE ASSEMBLY |
| Job Number | : 30421 | | |
| Estimate Number | : 10257 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D212664201 |
| This Issue | : 1/24/2007 | Drawing Number | : D212-664-241 REV <i>B</i> |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>N/A</i> | Drawing Revision | : <i>B</i> |
| Previous Run | : 30420 | Material | : <i>N/A</i> |
| Written By | : <i>[Signature]</i> | Due Date | : 2/28/2007 |
| Checked & Approved By | : <i>[Signature]</i> | Qty: | 1 Um: Each |
| Comment | : Est Rev:E 04.02.16 Reformat K/DS Est Rev:F 06-03-29 Remove Coments on Pick List JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-201CHG0023 *col* *KS 07.05.04* *(1)*

2.0

D6006129

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6006-129 Crosstube *B26550*

Check OD = 3.250"; ID = 2.220"

mk *07/01/30* *1*

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

mk *07/01/30* *1*

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

mk *07/01/30* *1*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Wednesday, 1/24/2007 4:44:08 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 30421

Part Number: D212664201

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|------------|----------------------------|
| 5.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
|-----|------------|----------------------------|



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA114

ml 07/01/31

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241.

| | | |
|-----|-----|------------------------------|
| 6.0 | QC1 | INSPECT ALL DIM TO DIM SHEET |
|-----|-----|------------------------------|



Comment: INSPECT ALL DIM TO DIM SHEET

ml 07/01/31

| | | |
|-----|-----|--------------|
| 7.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

En 07/02/01

| | | |
|-----|------------|----------------------------|
| 8.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
|-----|------------|----------------------------|



Comment: MORI SEIKI CNC LATHE LARGE

1-Remove sand and plugs

2-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241

ml 07/01/31

| | | |
|-----|----------------|-------------------------|
| 9.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

ST / ml 07-02-02

| | | |
|------|-----|------------------------------|
| 10.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|------|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

DP 7-2-5

| | | |
|------|-----------------|----------------------------|
| 11.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|------|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of machining

DP / ml 07-02-05

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 30421

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE/DP 7-2-5

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-241 using CNC bender program 212-af and Folio FT007

EL/IT 7-2-13

14.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

For 250
per D.S. B30423, B30422

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

3DP
7-5-30
JB 7-5-31

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

JB 7-5-31

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

For 050

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

For 06050

0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 3908

C2071001060

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Job Number: 30421

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: DIMENSIONAL CHECK

Inspect for damage & ensure results are as per Dwg D212-664-241

22.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

23.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

24.0

D2856600

Abrasion Strip



Comment: Qty.: 0.8400 f(s)/Unit Total: 0.8400 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600-1009 Abrasion Strip

magnabond B103628

time 2:00 pm

rubber strips D3595 B22894 RT 07-07-07

25.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2940-1 Support 24367

RT 07-07-05

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|---|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 07/07/09 | # 24 | ADD magnahans installation and Batch # and fire Also Rubber Strips and Batch #. (D3535) | En | 07/07/09 | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/09

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Date: Wednesday, 1/24/2007 4:44:09 PM
User: Kiril Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 30421

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28

Clamp 102534

RT 07-07-09

27.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

~~1-Install abrasion strips as per QSI-005 using DT8582~~

Marmband

2-Install supports and clamps as per Dwg D212-664-241. Torque clamps to 80-100 in lb.

mm 07 07 09 (1)

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/09 (x1)

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

30.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: B26249-1

31.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M103446

32.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M101428-1

En 07/07/09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH AFT X-TUBE ASSEMBLY

Job Number: 30421

Part Number: D212664201

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: 7103641 ✓

34.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: 14101660 ✓

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-201

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C 70710710

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|---|---------------------|--------------|
| DART AEROSPACE LTD | Work Order: | 30421 |
| Description: Crosstube Assembly (205/212 High Aft) | Part Number: | D212-664-241 |
| Inspection Dwg: D212-664-241 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

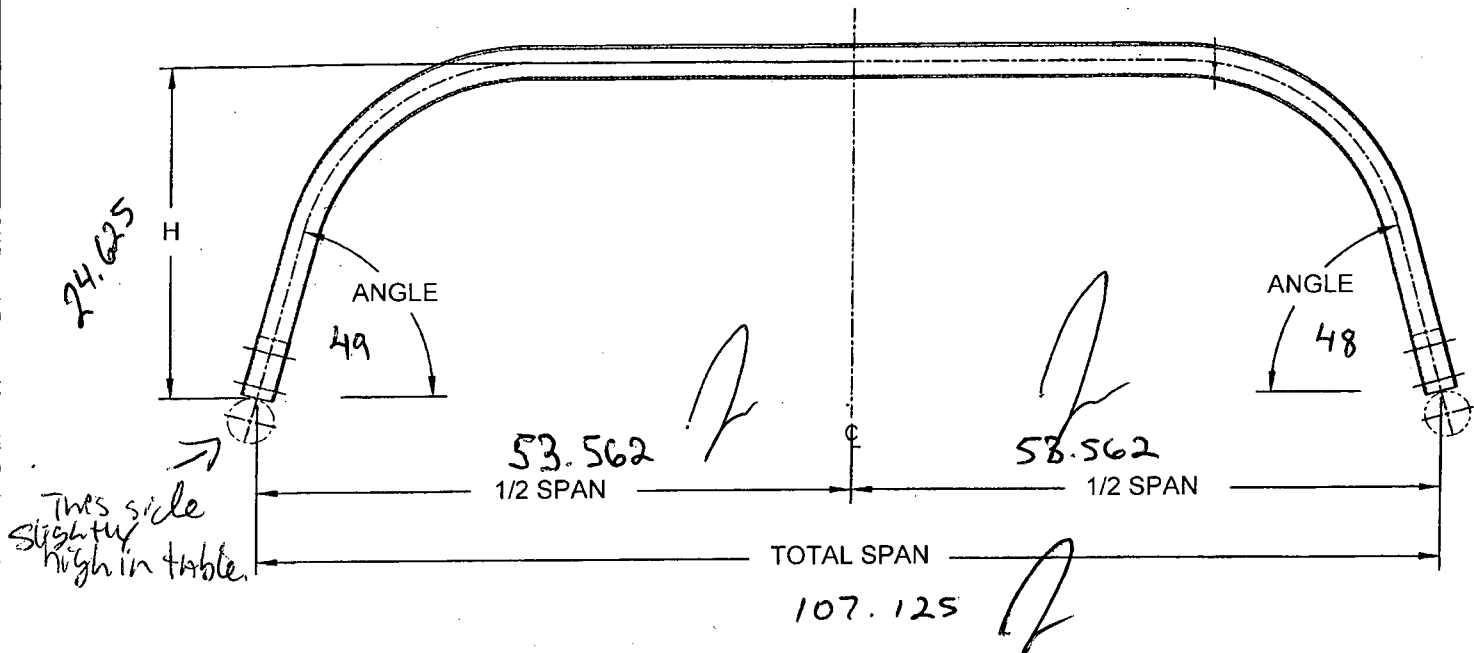
☒ First Article
 ☐ Prototype

| | Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|--------|---------------------------------------|---------------|---------------------|--------|--------|-------------------------|----------|
| SIDE A | 0.200 | +/-0.010 | 0.208 | — | | | |
| | R0.063 | +/-0.010 | R0.063 | — | | | |
| | 2.990 | +0.005/-0.000 | 2.991 | — | | | |
| | 5.237 | +/-0.030 | 5.237 | — | | | |
| | 2.600 | +0.005/-0.000 | 2.603 | — | | | |
| | 2.686 | +0.005/-0.000 | 2.691 | — | | | |
| | 2.770 | +0.005/-0.000 | 2.774 | — | | | |
| | 2.854 | +0.005/-0.000 | 2.857 | — | | | |
| | 2.938 | +0.005/-0.000 | 2.941 | — | | | |
| | 3.021 | +0.005/-0.000 | 3.026 | — | | | |
| | 3.133 | +0.005/-0.000 | 3.137 | — | | | |
| | 3.179 | +0.005/-0.000 | 3.180 | — | | | |
| | | | | | | | |
| SIDE B | 0.200 | +/-0.010 | 0.206 | — | | | |
| | R0.063 | +/-0.010 | R0.063 | — | | | |
| | 2.990 | +0.005/-0.000 | 2.991 | — | | | |
| | 5.237 | +/-0.030 | 5.237 | — | | | |
| | 2.600 | +0.005/-0.000 | 2.602 | — | | | |
| | 2.686 | +0.005/-0.000 | 2.690 | — | | | |
| | 2.770 | +0.005/-0.000 | 2.774 | — | | | |
| | 2.854 | +0.005/-0.000 | 2.858 | — | | | |
| | 2.938 | +0.005/-0.000 | 2.942 | — | | | |
| | 3.021 | +0.005/-0.000 | 3.026 | — | | | |
| | 3.133 | +0.005/-0.000 | 3.138 | — | | | |
| | 3.179 | +0.005/-0.000 | 3.184 | — | | | |
| | 124.36 | +/-0.020 | 124.370 | — | | | |
| | | | | | | | |
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|---------------------|----------|--------------------|----------|----------------------------|-----|
| Measured by: | gmk | Audited by: | Dr | Prototype Approval: | N/A |
| Date: | 07/01/31 | Date: | 07/02/01 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A | 05.04.27 | New Issue (P/O D412-664-201) | KJ/JLM | |
| B | 06.03.09 | Tolerance for 5.237 was +/-0.001 | KJ/JLM | |

Crosstube Bend Dimension Sheet



PART NUMBER: 1212664201

BATCH NUMBER: 30421

DRAWING: 1212664241 REVISION: B

H: 24.30

1/2 SPAN: 53.72

TOTAL SPAN: 107.44

ANGLE: 50

For 1042

QC 15: 11

DATE: 07/03/08

QTY: 1

*don't fit in table jig
Pough on jig*



| | | | |
|------------------------|-------------------------|--|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D212-664-241 | REV. B SHEET 1 OF 3 |
| DATE 05.02.04 | | TITLE CROSSTUBE ASS'Y (205/212 HI AFT) | SCALE NTS |
| A | 00.12.12 | NEW ISSUE | |
| B | 05.02.04 | ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES | |

RELEASED
05.06.09 [Signature]

| Qty | Part Number | Description |
|-----|----------------|---------------------------------------|
| X | D212-664-241 | CROSSTUBE ASSEMBLY (205/212 HIGH AFT) |
| 1 | D6006-129 | CROSSTUBE |
| 2 | D2940-1 | SUPPORT |
| 2 | D2856-600-1009 | ABRASION STRIP |
| 4 | MS21920-28 | CLAMP |

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.36±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2940-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

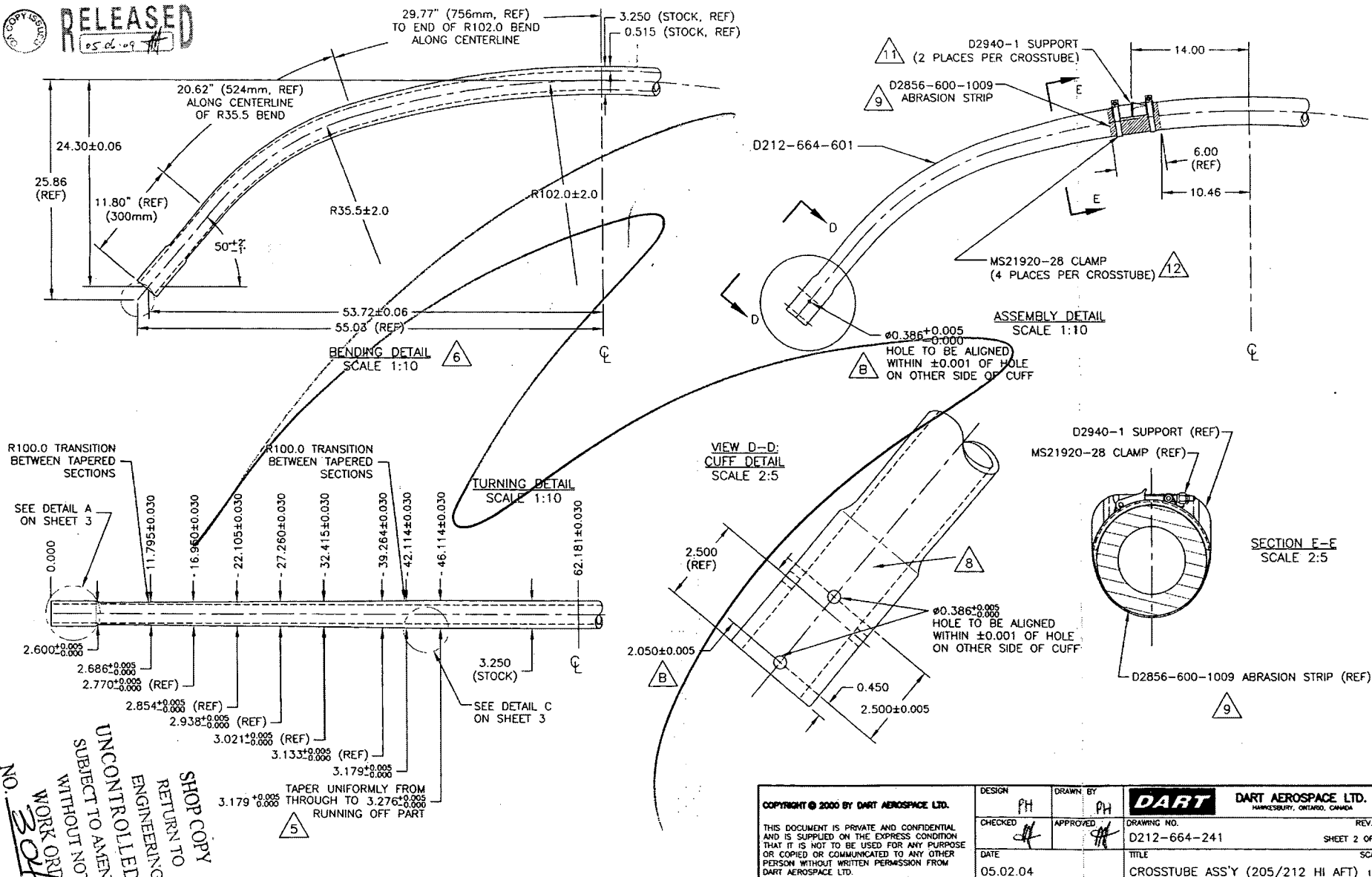
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 30421

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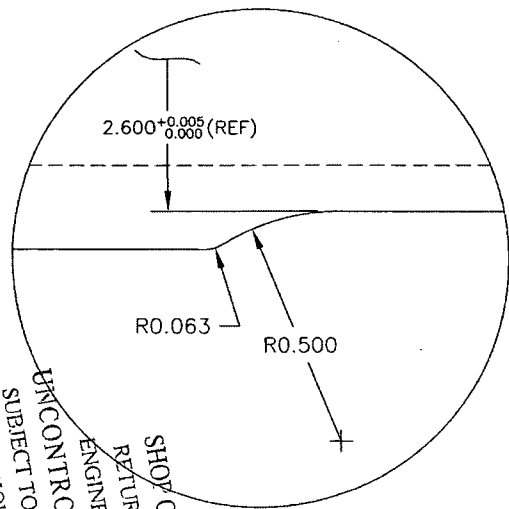
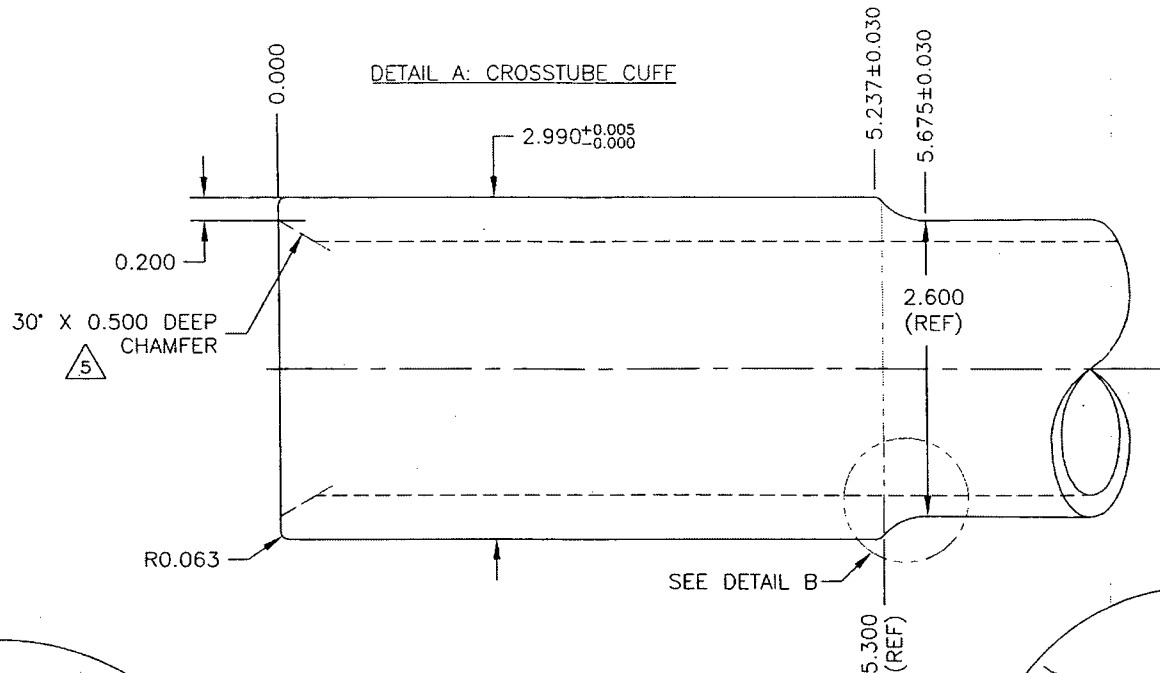
RELEASED
05.06.09



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|--|--|---------|----------|----------|----|----------------------------------|---|
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| | | DATE | 05.02.04 | | | D212-664-241 | SHEET 2 OF 3 |
| | | | | | | TITLE | SCALE |
| | | | | | | CROSSTUBE ASS'Y (205/212 HI AFT) | 1:10 |

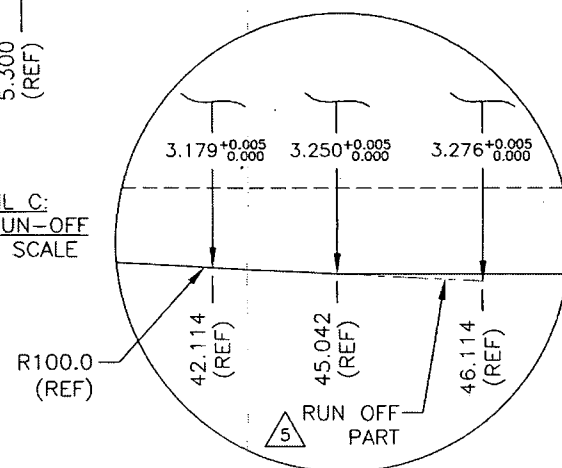
NO. 30421
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
30421

RELEASED
05-26-09



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



NO. 30421
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
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|--|--|----------------------------------|----------|-----------------------------|--------------|
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| CHECKED | | PH | PH | DRAWING NO. | REV. B |
| DATE | | 05.02.04 | | D212-664-241 | SHEET 3 OF 3 |
| TITLE | | CROSSTUBE ASS'Y (205/212 HI AFT) | | SCALE | |
| | | | | 1:1 | |



HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 36580

A.M.O. Number: 46/90

NON-DESTRUCTIVE TESTING REPORT

AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

INSPECTION REQUIREMENTS

Carry out FPI of (7) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty (1) P/N D212-664-101 S/N B31356.

Qty (1) P/N D412-664-203 S/N B30186.

Qty (2) P/N D212-664-201 S/N's B30423 and B30421.

Qty (3) P/N D412-664-245 S/N's B32445, B32447 and B32446.

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on (7) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)
Ardrox 970P25E Batch #04B503.

(7) cross tubes inspected. (7) PASSED / (0) FAILED.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

DATE

June 06, 2007

INSPECTION
STAMP(S)

CUSTOMER INFORMATION

CUSTOMER: Dart Aerospace

P.O. NUMBER

PO 00003908

ADDRESS:

CONTACT NAME:

Linda Lacelle

LABOUR @

\$

MATERIALS @

TRAVEL EXPENSES @

GST

HOTEL EXPENSES @

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT

**REFERENCE ONLY**

RELEASED
07.04.24
PER E.C.N. 285

| | | | |
|---------------------|--------------------------------|--|------------------------|
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| CHECKED <i>J</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D212-664-241 | REV. C SHEET 1 OF 3 |
| DATE 07.03.08 | | TITLE CROSSTUBE ASS'Y (205/212 HI AFT) | SCALE NTS |
| A | 00.12.12 | NEW ISSUE | |
| B | 05.02.04 | ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES | |
| C | 07.03.08 | REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS | |

| Qty | Part Number | Description |
|-----|----------------|---|
| X | D212-664-241 | CROSSTUBE ASSEMBLY (205/212 HIGH AFT) |
| 1 | D6006-129 | CROSSTUBE |
| 2 | D2940-1 | SUPPORT |
| 4 | D3595-063-530 | RUBBER CUSHION |
| 4 | MS21920-28 | CLAMP (OR MS21920-30) |
| A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

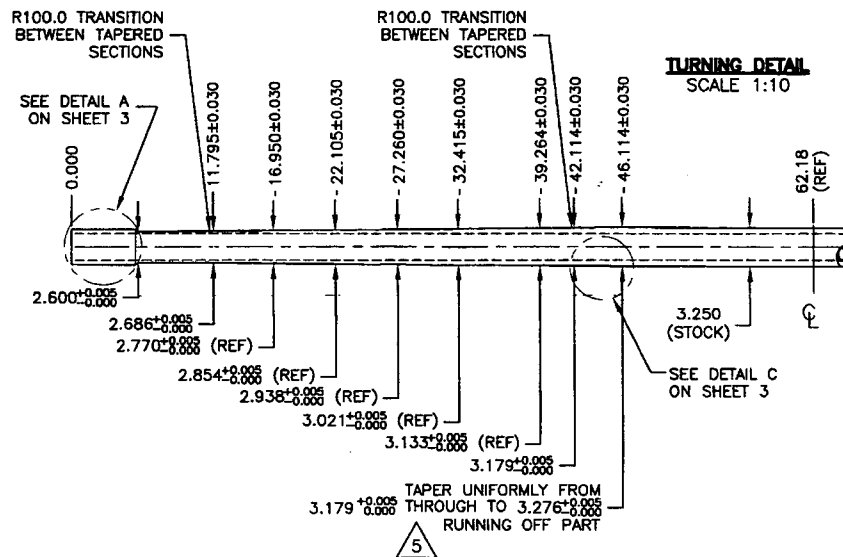
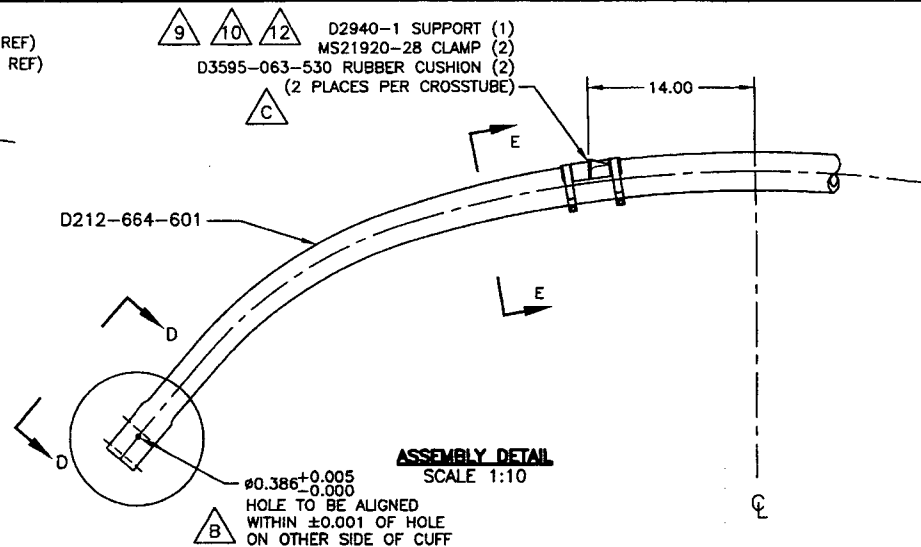
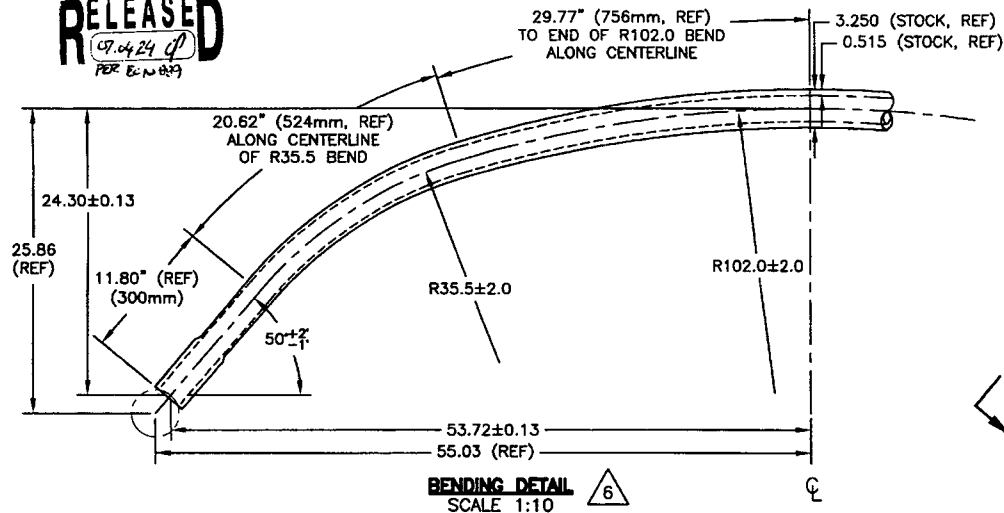
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.36±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 SUPPORT ON TOP SIDE OF CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
NOTE: MS21920-30 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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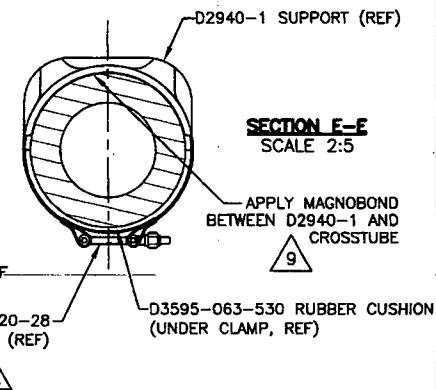
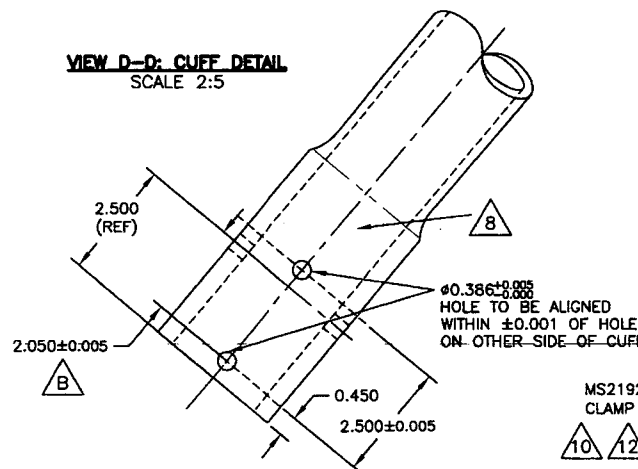
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PER 6-10-03



VIEW D-D: CUFF DETAIL
SCALE 2:5



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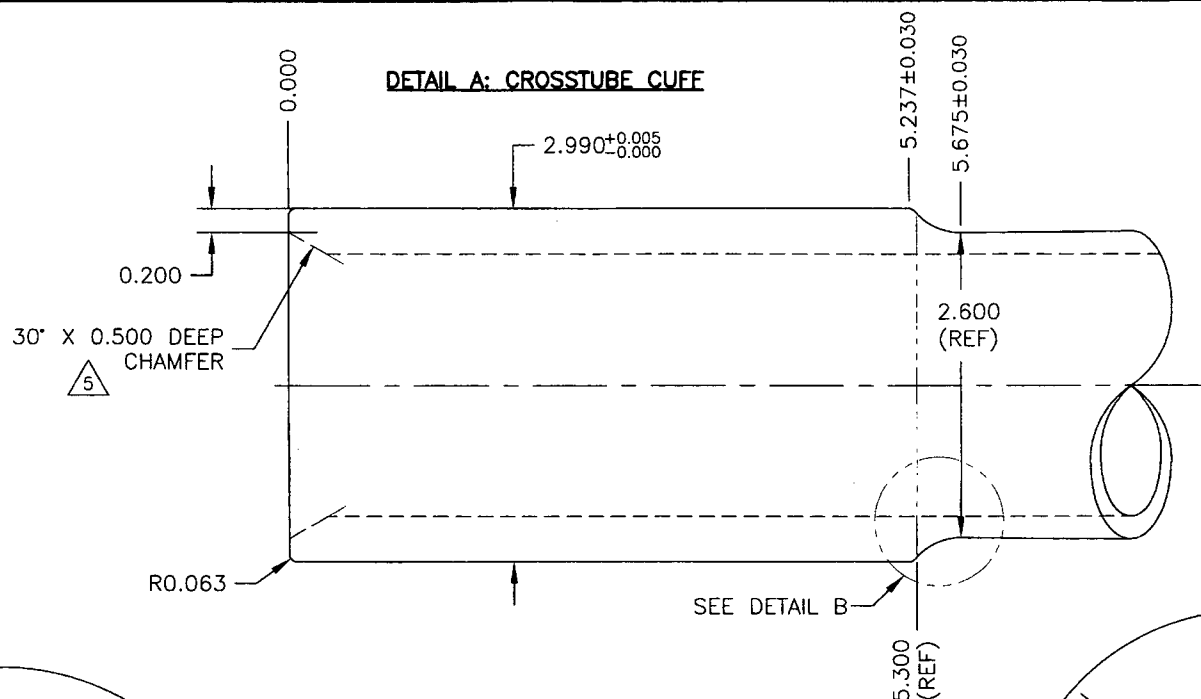
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| CHECKED J | APPROVED A | DRAWING NO. D212-664-241 | REV. C SHEET 2 OF 3 |
| DATE 07.03.08 | TITLE CROSSTUBE ASS'Y (205/212 HI AFT) | SCALE 1:10 | |

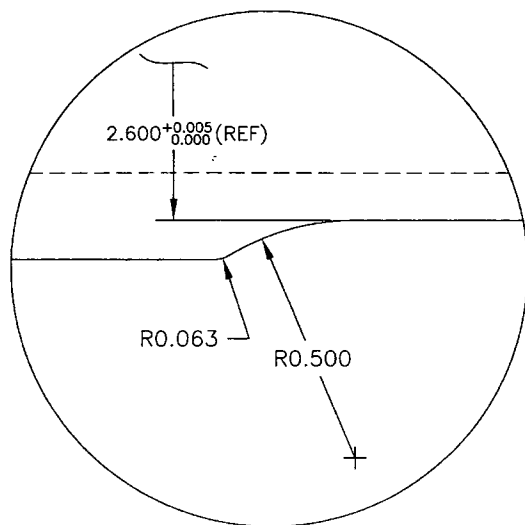
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128 E-2889

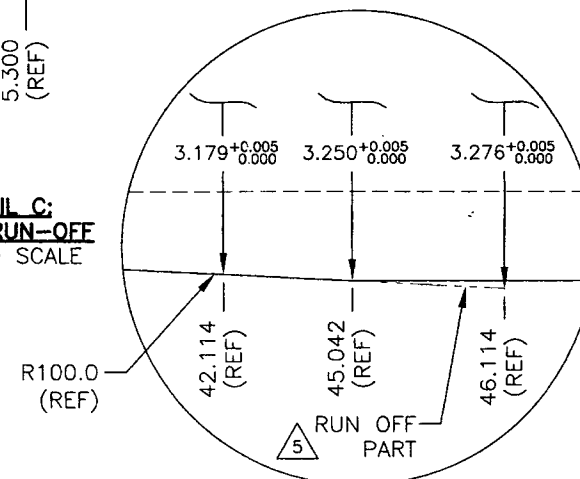
DETAIL A: CROSSTUBE CUFF



DETAIL B: CUFF
TRANSITION
SCALE 4:1



DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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DESIGN
CHECKED
DATE
07.03.08

DRAWN BY
APPROVED
DATE

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D212-664-241

TITLE
CROSSTUBE ASS'Y (205/212 HI AFT)

REV. C
SHEET 3 OF 3

SCALE
1:1